

# Work Order ID 53322

October 30, 2009 10:18:24 AM



Page 1

Item ID: D412-630-032

Accept



Setup Start



Revision ID: M

Stop



Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 30/10/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 16/11/2009 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: 10/11/09 Date: 09-10-30 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN D412-630	Rev M

100 0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D412-630 bluefile & type labels per PPP412-630-031 CHG001

3 ECN 09-646  
DWGS CHNG

10/11/12 BG 09/11/12

110 0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D412-630 p.17 \*\*\*\*ensure tension to retract step is 11 to 18 lbs before installing lockwire.\*\*\*\*

10/11/12 A/A MS2099SC41 batch: M101537

10/11/12 2

120 0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

\*\*\*\*ensure tension to retract step is 11 to 18 lbs \*\*\*\* Test fit on aircraft in Eng. lab.

2 10/11/12

**Work Order ID 53322**

October 30, 2009 10:18:24 AM



Page 2

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Start Date: 30/10/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 16/11/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Pick Kit	0.00							
Packaging 	Memo	0.00				9/11/12			(Signature)
Packaging									
140 	QC4- 100% Inspect kits for completeness	0.00							
QC 	Memo	0.00				10/09/11/12			V2
Quality Control									
150 	Packaging	0.00							
Packaging 	Memo	0.00				9/11/12			(Signature)
Packaging	Identify and pack for shipping as per PPP D412-630-031								
	Location: 31								
	Rev: C								

# Work Order ID 53322

October 30, 2009 10:18:24 AM



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Item ID: D412-630-032

Accept



Setup Start



Revision ID: M

Stop



Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 30/10/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 16/11/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

09/11/12

MR

69-11-12

# Picklist Print

October 30, 2009 10:18:27 AM

Page 1

Work Order ID: 53322

Parent Item: D412-630-032RevM

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 30/10/2009

Required Date: 16/11/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN310-4		Purchased	No				Each	84.0000	4.0000			
												
NUT												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

84

110098

34

112969

50

AN310-4		Purchased	No				Each	84.0000	2.0000			
												
NUT												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

84

110098

34

112969

50

AN310-5		Purchased	No				Each	32.0000	4.0000			
												
NUT												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

32

105280

2

110552

2

111060

28

# Picklist Print

Page 2

October 30, 2009 10:18:27 AM

Work Order ID: 53322



Parent Item: D412-630-032RevM



Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 30/10/2009

Required Date: 16/11/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN310-7		Purchased	No				Each	39.0000	2.0000			
NUT												

*9/30/11/12*

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	39	
103286	19	
111916	20	

*2*

AN3C5A		Purchased	No				Each	546.0000	6.0000			
Bolt												

*9/11/12* *2x50*

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	546	
111424	8	
111707	69	
112314	1	
112641	468	

*6x50*

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Start Date: 30/10/2009

Required Date: 16/11/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN44-C12 eyebolt		Purchased	No				Each	35.0000	2.0000			
<div> <div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>111176</div> <div>111888</div> </div> <div> <div>Loc Qty</div> <div>35</div> <div>15</div> <div>20</div> </div> <div> <div>Loc Code</div> <div></div> </div>												
AN4C14 BOLT		Purchased	No				Each	23.0000	2.0000			
<div> <div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>110552</div> </div> <div> <div>Loc Qty</div> <div>23</div> <div>23</div> </div> <div> <div>Loc Code</div> <div></div> </div>												
AN4C15 BOLT		Purchased	No				Each	16.0000	2.0000			
<div> <div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>111303</div> </div> <div> <div>Loc Qty</div> <div>16</div> <div>16</div> </div> <div> <div>Loc Code</div> <div></div> </div>												

# Picklist Print

October 30, 2009 10:18:27 AM

Work Order ID: 53322

Parent Item: D412-630-032RevM

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)


Start Date: 30/10/2009

Required Date: 16/11/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4CH3 )  SS Bolt		Purchased	No				Each	42.0000	4.0000			

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

42

111261

7

111978

35

Purchased

No

Each

31.0000

2.0000

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

ST

31

103248

11

111279

20

Purchased

No

Each

33.0000

2.0000

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

ST

33

10121

2

110552

31

AN5C11

BOLT

AN5C15

BOLT

9509/11/12

2

9/11/12 SP

2x

9/11/12 (2x) SP

2x SP

# Picklist Print

October 30, 2009 10:18:27 AM

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Parent Item: D412-630-032RevM

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 30/10/2009

Required Date: 16/11/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10 WASHER		Purchased	No				Each	293.0000	14.0000			
<div>Warehouse Location</div> <div>Main Warehouse</div> <div>ST</div> <div>111965</div> <div>Loc Qty</div> <div>293</div> <div>293</div> <div>Loc Code</div>												
AN960C516 WASHER		Purchased	No				Each	225.0000	2.0000			
<div>Warehouse Location</div> <div>Main Warehouse</div> <div>ST</div> <div>102842</div> <div>112532</div> <div>Loc Qty</div> <div>225</div> <div>125</div> <div>100</div> <div>Loc Code</div>												
D3443-041RevC Strut Weldment Assembly		Manufactured	No				Each	0.0000	2.0000			
D3443-043RevC Strut Weldment Assembly		Manufactured	No				Each	0.0000	2.0000			
D3443-9RevC Pin		Manufactured	No				Each	0.0000	4.0000			

9/11/12 SL

14x54

9/11/12 SL

2x54

B53326 (20)

9/30/11/12

B53325 (12)

B48250 (12)

9/30/11/12

B48124 (42)

9/30/11/12



# Picklist Print

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Work Order ID: 53322

Parent Item: D412-630-032RevM

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 30/10/2009

Required Date: 16/11/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3454-1RevB 1

Manufactured

No

Each

14.0000

2.0000



Bushing

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

14

44588

2

46135

12

Each

46.0000

4.0000

D3454-3RevB 7

Manufactured

No



Bushing

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

46

48125

46

Each

13.0000

4.0000

D3454-5RevB 1

Manufactured

No



Bushing

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

13

46137

13

9/11/12 SP

2x SP

9/11/12 SP

4x SP

9/11/12

SP  
(2x)

7x SP

# Picklist Print

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Work Order ID: 53322

Parent Item: D412-630-032RevM

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)




Start Date: 30/10/2009

Required Date: 16/11/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3454-7RevB  Bushing		Manufactured	No				Each	24.0000	4.0000		8/30/11/12	
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>46132</div> <div>24</div> <div>24</div> <div>Loc Qty</div> <div>Loc Code</div>												
D3455-1RevA  Spacer		Manufactured	No				Each	67.0000	4.0000		4 8/30/11/12	
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>46138</div> <div>67</div> <div>67</div> <div>Loc Qty</div> <div>Loc Code</div>												
D3455-1RevA  Spacer		Manufactured	No				Each	67.0000	8.0000		4 9/11/12 50 (2x)	
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>46138</div> <div>67</div> <div>67</div> <div>Loc Qty</div> <div>Loc Code</div>												

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Shop Packet Print

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# Picklist Print

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October 30, 2009 10:18:27 AM

Work Order ID: 53322



Parent Item: D412-630-032RevM



Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 30/10/2009

Required Date: 16/11/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3455-3RevA 1 Manufactured No

Each 41.0000 4.0000



Spacer



9/11/12 SD

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

41

46139

3

48126

38

Each

3.0000

2.0000

3x SD

D3462-042RevC 1 Manufactured No



Bracket Assembly



9/11/12 SD

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3

35860

1

48139

2

Each

0.0000

2.0000

2x SD

D3463-042RevB 1 Manufactured No



Step Weldment Assembly



9/11/12 SD  
B33312 2x

# Picklist Print

October 30, 2009 10:18:27 AM

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Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)


Start Date: 30/10/2009

Required Date: 16/11/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3465-1RevB  Washer		Manufactured	No				Each	69.0000	2.0000			

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

69

41692

7

46134

62

Each

5,079.000 6.0000



2

alulia

50  
9X

Warehouse  
Location

Loc Qty

Loc Code

OFFSHORE

FG

80

103691

80

Main Warehouse

ST

4999

111819

78

112243

39

112314

4882

6X50

MS21043-3



Nut

# Picklist Print

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October 30, 2009 10:18:28 AM

Work Order ID: 53322

Parent Item: D412-630-032RevM

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 30/10/2009

Required Date: 16/11/2009

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Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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MS24665-227 Purchased No



COTTER PIN

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

32

111359

32

MS24665-227 Purchased No



COTTER PIN

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

32

111359

32

MS24665-227 Purchased No



COTTER PIN

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

278

111041

278

9/11/12 SP

4x 50

8509/11/12

2

9/11/12 EX SP

4x 50

# Picklist Print

October 30, 2009 10:18:28 AM

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Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)


Start Date: 30/10/2009

Required Date: 16/11/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS24665-302  Cotter Pin		Purchased	No				Each	33.0000	2.0000		EB 09/11/12	

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

33

111359

33

Each

300.0000 2.0000



2

9/11/12

50 (2x)

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG

44

103286

17

103691

27

Main Warehouse

ST

256

109430

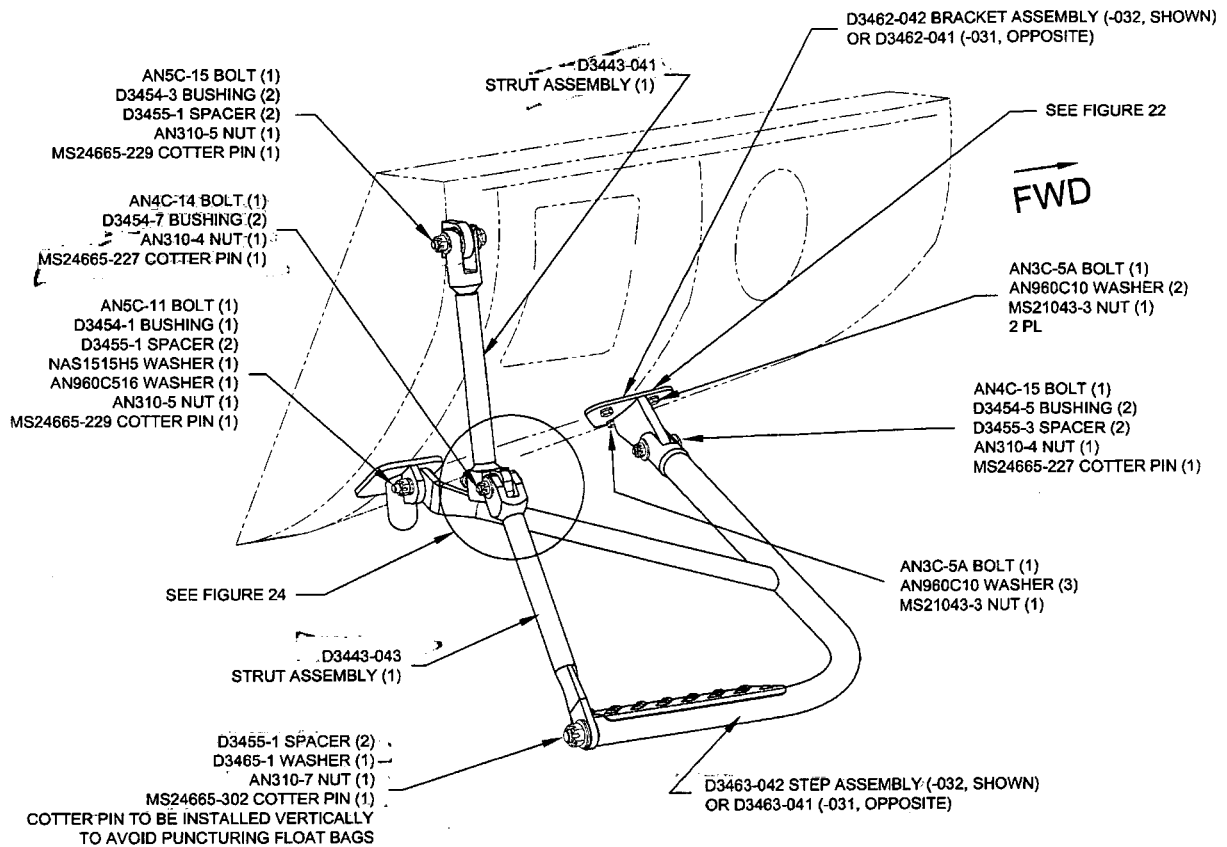
256

2x 50

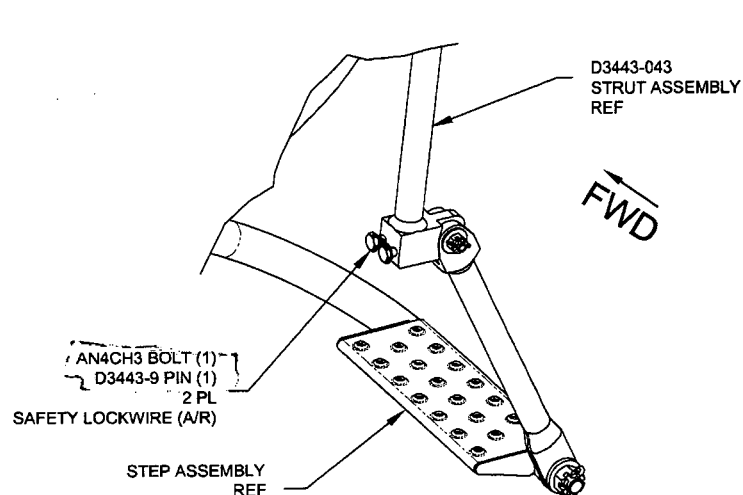
NAS1515H5 /



Washer



**FIGURE 23 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)  
D412-630-031 LH (Opposite)**



**FIGURE 24 – Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)  
D412-630-031 LH (Opposite)**

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Revision: **M**  
Date: 08.12.12

REFERENCE ONLY

DART AEROSPACE LTD.

D412-630  
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Qty -031	Qty -032	Part Number	Description
X		D412-630-031	PILOT/CO-PILOT STEP, LH (FOLDING)
	X	D412-630-032	PILOT/CO-PILOT STEP, RH (FOLDING)
1	1	D3443-041	STRUT ASSEMBLY
1	1	D3443-043	STRUT ASSEMBLY
2	2	D3443-9	PIN
1	1	D3454-1	BUSHING
2	2	D3454-3	BUSHING
2	2	D3454-5	BUSHING
2	2	D3454-7	BUSHING
6	6	D3455-1	SPACER
2	2	D3455-3	SPACER
1		D3462-041	BRACKET ASSEMBLY
	1	D3462-042	BRACKET ASSEMBLY
1		D3463-041	STEP ASSEMBLY
	1	D3463-042	STEP ASSEMBLY
1	1	D3465-1	WASHER
2	2	AN310-4	NUT
2	2	AN310-5	NUT
1	1	AN310-7	NUT
3	3	AN3C-5A	BOLT
1	1	AN44-C12	* EYEBOLT
1	1	AN4C14	BOLT
1	1	AN4C15	BOLT
2	2	AN4CH3	BOLT
1	1	AN5C11	BOLT
1	1	AN5C15	BOLT
7	7	AN960C10	WASHER
1	1	AN960C516	WASHER
3	3	MS21043-3	NUT
2	2	MS24665-227	COTTER PIN
2	2	MS24665-229	COTTER PIN
1	1	MS24665-302	COTTER PIN
1	1	NAS1515H5	WASHER

\* USE AN44-C12 EYEBOLT WHEN D412-630-031/-032 IS INSTALLED IN CONJUNCTION WITH D412-630-023/-024/-033/-034™ HELI-ACCESS-STEP

53322

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Revision: M  
Date: 08.12.12



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries